

Date: Wednesday, 12/7/2005 8:26:42 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BAFFLE ASSEMBLY	
Job Number	: 25151		Part Number	: D3276041	
Estimate Number	: 11264		Drawing Number	: D3276 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/7/2005 S.O. No. : N/A		Drawing Revision	: B	
Prsh't Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 12/30/2005	
Previous Run	: N/A		Qty:	10 Um: Each	
Written By	: See comment below			30 u	
Checked & Approved By	: See comment below			Z3	
Comment	: Est Rev:A New Issue 05-12-06 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6S040	6061-T6 .040 Sheet		
		Comment: Qty.: 1.0715 sf(s)/Unit Total: 10.7153 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.040" thick (M6061T6S.040) Batch: M19059		
2.0	SHEAR	SHEAR J.L		05-12-10 30
		Comment: SHEAR Cut blank: 8.975" x 16.375" grain along 8.975"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	J.L	05-12-10 30
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA498 and Dwg D3276	J.L	05-12-10 30
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	J.L	05-12-10 30
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		05-12-10 30
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1		
		1-Deburr		SB 05/12/14 23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod. Mgr	Approval QC Inspector
05/12/13	8	Took 1 for Template	See D3276-042	8B	05/12/13	1	<i>05/12/14</i>	<i>05/12/14</i>	<i>05/12/14</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 05/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 25151

Part Number: D3276041

Job Number:



Seq. #: Machine Or Operation:

Description :

2-Roll as per Dwg D3276

SB 05/12/14 23

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SB 05/12/14 23

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 05/12/15 23

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 05/12/15 23

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 D2464 3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s)

Pick:

Qty Part Number	Description	Batch
27.0" D2464	Neoprene Seal	B21404

324"

B21404

324"

B25153

SB 05/12/15 23

14.0 D32763 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3276-3	Decal	B22545

SB 05/12/15 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:43 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 25151

Part Number: D3276041

Job Number:



Seq. #:	Machine Or Operation:	Description :
15.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3276	SB 06/01/03 23
16.0	QC5	INSPECT WORK TO CURRENT STEP
		 J 06.01.03
	Comment: INSPECT WORK TO CURRENT STEP	
17.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 103	C 06/01/04 23
18.0	DC	DOCUMENT CONTROL
		 D 06/01/04 23
	Comment: DOCUMENT CONTROL Inspection Level 21	5 06/01/04 23

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

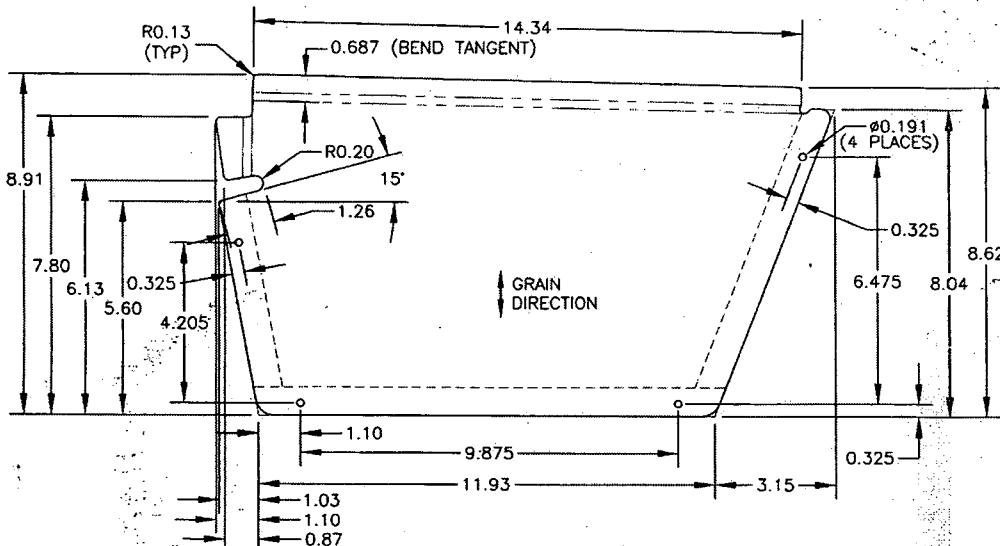
DART AEROSPACE LTD	Work Order:	25151
Description: Baffle	Part Number:	D3276-1
Inspection Dwg: D3276	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

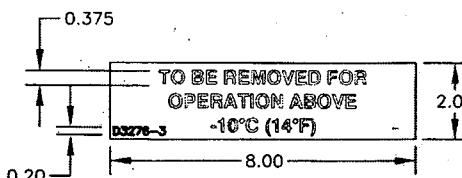
Measured by:	J.L.	Audited by:	S.P.	Prototype Approval:	N/A
Date:	05-12-10	Date:	05/12/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D044-717-011	KJ/JLM	



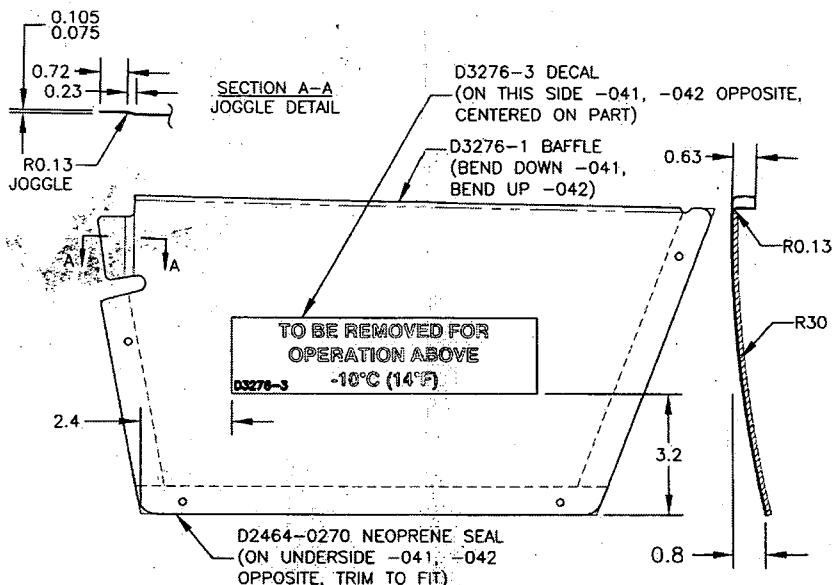
D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED
05-02-02

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD.
CP	CP	HORNSEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3276
		REV. B SHEET 1 OF 1
DATE	TITLE	SCALE
05.01.25	BAFFLE ASSEMBLY	1:3

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